

Date: Thursday, 19/03/2009 11:05:43 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : HANDLE WELDMENT
<b>Job Number</b> : 46579	
<b>Estimate Number</b> : 10333	
<b>P.O. Number</b> :	<b>Part Number</b> : D2530
<b>This Issue</b> : 19/03/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2530 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 45683	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 31/03/2009 <b>Qty:</b> 10 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUD 09.03.19</u>	
<b>Comment</b> : Est Rev:E Removed Purchasing 05-11-07 JLM	

## Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0

M304TR0750W049

304 RD Tube .750 x .049W



(10x)

**Comment:** Qty.: 3.0602 f(s)/Unit Total : 30.6023 f(s)

Material: 304/316 SS Seamless Tubing 0.75" OD x 0.049" wall(M304TR0.750W.049)

Batch: M1107518

M-L 09/04/13

2.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



(10x)

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Cut to length as per Dwg D2536

2-Deburr

M-L 09/04/13

3.0

QC5

INSPECT WORK TO CURRENT STEP

**Comment:** INSPECT WORK TO CURRENT STEP

S 09/04/13 (X10)

4.0

D2534

Lock Plate

**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

QTY

Part #

Description

Batch

2

D2534

Lock Plate

B438513

PC 09.04.13

5.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



(X10)

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301

PC 09.04.13

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 19/03/2009 11:05:43 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE WELDMENT

Job Number: 46579

Part Number: D2530

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Deburr

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-04-14 (10)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

509/04/14 (10)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M 105042

START TIME:

1:20

OVEN TEMPERATURE:

320

FINISH TIME:

1:50

BL 09-04-14

(10)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FZ 09/04/14

(10)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 506

9/4/14

SD

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/15

Job Completion



MF  
09-04-25

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



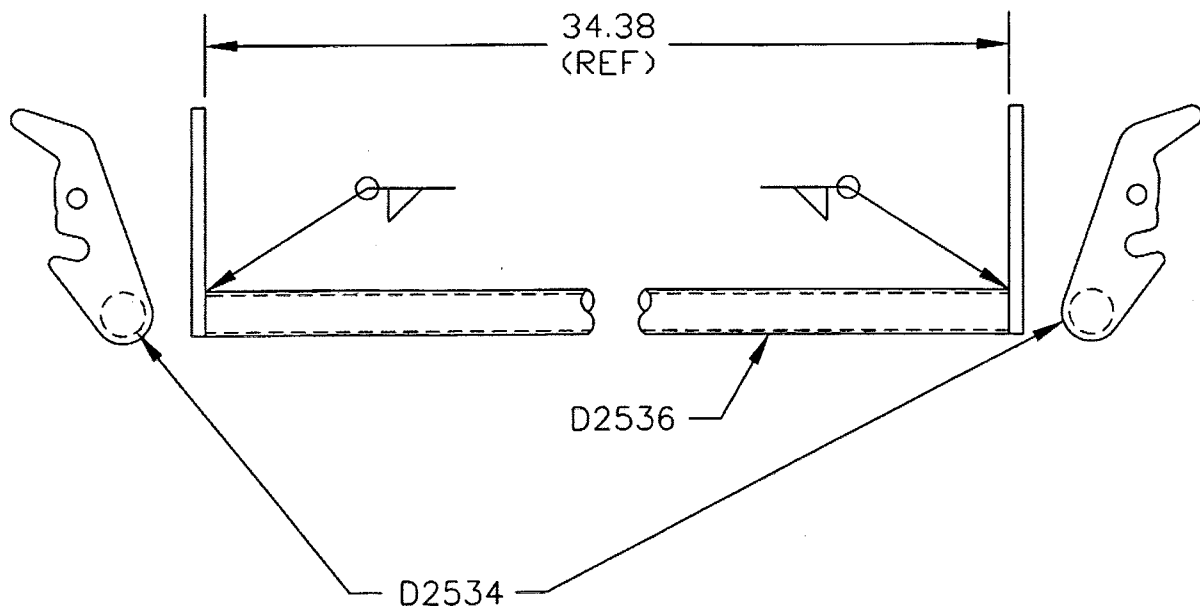
DESIGN B WILLIAMS	DRAWN BY PH	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2530	REV. B SHEET 1 OF 1
DATE 04.12.14		TITLE HANDLE WELDMENT	
A	96.06.18	NEW ISSUE	
B	04.12.14	UPDATE NOTES AND DIMENSIONS	

RELEASED

04.12.16 *[Signature]*

PART LIST -- D2530

QTY	PART NUMBER	DESCRIPTION
X	D2530	HANDLE WELDMENT
1	D2536	HANDLE
2	D2534	LOCK PLATE



D2530 HANDLE WELDMENT

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
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WITHOUT NOTICE  
WORK ORDER  
NO. *440579*